

129-011

Dart Aerospace Ltd.

Date: Friday, 23/01/2009 8:48:36 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MEDIUM BELL
 Job Number : 45201A
 Estimate Number : 12129
 P.O. Number :
 This Issue : 23/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D412729041
 First Issue : // Type : LARGE FAB ASSY Drawing Number : DSK 092 REV B
 Previous Run : 44919A Drawing Revision : B
 Material :
 Due Date : 06/02/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JLO 09.01.23
 Comment : Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

N/A

2.0

D27287

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label B22554

SAD 09-04-23 (2)

✓

3.0

D3233041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly B45169

SAD 09-04-23 (2)

✓

4.0

D32331

Inside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer B43625

SAD 09-04-03 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0 D32333 Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer B42465 x2

B45170 x2

SAD 09-04-23 (2)

✓ 6.0 D33091 Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label B37078

SAD 09-04-23 (2)

✓ 7.0 D33093 Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label B43660 x1

B45273 x3

SAD 09-04-23 (2)

✓ 8.0 D3330041 Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment B45274

SAD 09-04-23 (2)

✓ 9.0 D3331041 Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly B37082

SAD 09-04-23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B44202 → 3 1 PART SCRAP

SAD 09-04-23 (2)

✓ 11.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly B44368X1

SAD 09-04-23 (2)

✓ 12.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B45081

SAD 09-04-23 (2)

✓ 13.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate B46344

SAD 09-04-23 (2)

✓ 14.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail B45280 X3

B45083 X3

SAD 09-04-23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B45084

SAD 09-04-23 (2)

✓ 16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring 44245

SAD 09-04-23 (2)

✓ 17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring 45180

SAD 09-04-23 (2)

✓ 18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B43352

SAD 09-04-23 (2)

✓ 19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer 110363

SAD 09-04-23 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 20.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span

M108200

SAN 09-04-23

(2)

✓ 21.0 HC12 1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

B16529

SAN 09-04-23

(2)

✓ 22.0 HC29 5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M110611

SAN 09-04-23

(2)

✓ 23.0 HC153 3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span

M110601

SAN 09-04-23

(2)

24.0 HN120 HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof

M102150

SAN 09-04-23

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HN177

5/16-18UNC Nylon LockNut

*



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-177 5/16"-18 UNC Nylon Lock Nut, Span

M110084 -?

SAD 09-04-23

(2)

✓ 26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M108200

SAD 09-04-23

(2)

✓ 27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

M109840

SAD 09-04-23

(2)

✓ 28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

102150

SAD 09-04-23

(2)

✓ 29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M110611

SAD 09-04-23

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 23/01/2009 8:48:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 45201A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M106512

SAD 09-04-23 (2)

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof 110138

SAD 09-04-23 (2)

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

→ M108862

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

SAD 09-04-23

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/24 (2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 45.201

P 9/4/24 (2)

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



- MF 09-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-04-23	#320	D3332-041	<i>[Signature]</i>	09-04-23	1		

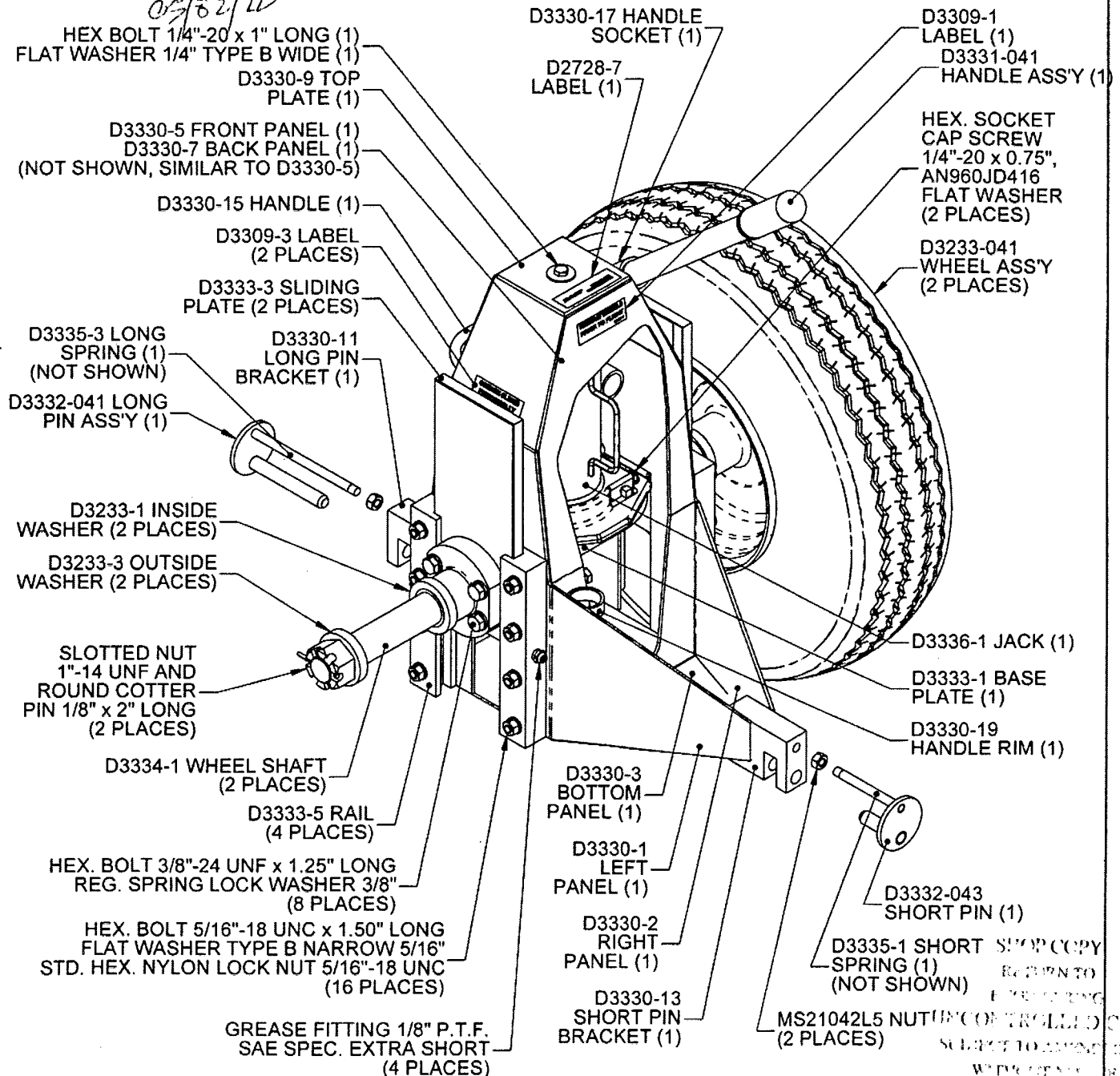
Part No: D412-729-041 PAR #: _____ Fault Category: Prod/Eng Lrg NCR: (Yes) No DQA: D Date: 09/04/28
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: A Date: 09/04/29

NCR: 45201A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-23	#320	D3332-041 WAS WELDED CROOKED DID NOT FIT into D3330-11	<i>[Signature]</i> 09-04-23	D3332-041 → 1 PIECE SCRAP NO REPLACE	<i>[Signature]</i> 09-04-23	<i>[Signature]</i> 09-04-23	<i>[Signature]</i> 09-04-23	<i>[Signature]</i> 09-04-23

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASSY	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE, NO. *452017*
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